



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5569-1
Job Sheet 182895-A

Accounting Job RD17-1048-01



Part No: D5569-1

Job Qty: 4 ea

Part Name: Skidtube Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/4/18

Job Tracking No:

Due Date: 9/14/18

Created By: Linda Lacelle

Type: R+D

Description:

Note: TBD DWG D5569-1 REV:A4 IPP REV A 18.08.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC2 Machining-2		18-10-05
120	CNC Vertical Machining	4 pcs	9/14/18	9/14/18	0.00	2.00	HAAS 5 Axis		
130	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC2 Machining-2		DAS
140	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC8 Machining-2		38
170	HandFinish	4 pcs	9/14/18	9/14/18	0.00	0.13	HandFinish1		9-89
180	Powdercoat	4 pcs	9/14/18	9/14/18	0.00	0.14	Powdercoat1		DR 18/10/16
190	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC3		BL 18/10/16
200	Packaging	4 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		30 DAS
210	QC21-SA	4 Ea	9/14/18	9/14/18	0.00	0.00	QC21		5-229 OCT 2 3 2018 9-89

Part Op 120 - 1-Machine as per Folio FC306 and Dwg. D5569-1
Descriptions: 180 - START TIME: 3:20 04:50 FINISH: 3:50 M839B
200 - LOCATION : FP001

DAS 21 OCT 2 3 2018 9-89

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S116069



Part: D5569-1

Job No: 182895-A

Serial No/Batch: S111475

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 10/16/18



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PRELIMINARY ISSUE

D5569-1
Job Sheet 182895

Accounting Job RD17-1048-01



Part No: D5569-1

Job Qty: 8 ea

Part Name: Skidtube Blade



Part Weight: 0 lbs

Job Created: 9/5/18

Due Date: 9/14/18

Type: R+D

Status: Scheduled

Job Tracking No:

Created By: Jason Leroux

Description:

Note: DWG D5569-1 REV:A4 IPP REV A 18.08.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

POSITIVE RECALL

EFFECTIVE AUTH 21
SEP 11 2018
RELEASED DATE 9-09
Priority: High

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Machining-2		 2018-08-19
100	Mori Seiki	8 pcs	9/14/18	9/14/18	0.00	2.67	Mori Seiki TL-40		
110	QC	8 pcs	9/14/18	9/14/18	0.00	0.00	QC2 Machining-2		
120	CNC Vertical Machining	8 pcs	9/14/18	9/14/18	0.00	4.00	HAAS 5 Axis		
130	QC	8 pcs	9/14/18	9/14/18	0.00	0.00	QC2 Machining-2		
140	QC	8 pcs	9/14/18	9/14/18	0.00	0.00	QC8 Machining-2		
150	Small Fab	8 pcs	9/14/18	9/14/18	0.00	2.00	Small Fab-5		
160	QC	8 pcs	9/14/18	9/14/18	0.00	0.00	QC5		
170	HandFinish	8 pcs	9/14/18	9/14/18	0.00	0.25	HandFinish1		
180	Powdercoat	8 pcs	9/14/18	9/14/18	0.00	0.28	Powdercoat1		
190	QC	8 pcs	9/14/18	9/14/18	0.00	0.00	QC3		
200	Packaging	8 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		
210	QC21-SA	8 Ea	9/14/18	9/14/18	0.00	0.00	QC21		

Part Op 100 - NOTE: OAL Before bending is 17.513" 1-Cut blanks at 17.75" 2-Turn OD, ID, and Face to length as per dwg. D5569
Descriptions: and folio FC306

120 - 1-Machine as per Folio FC306 and Dwg. D5569-1

150 - -Bend blade as per dwg.

180 - START TIME: _____

200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6008-132	Crosstube Extrusion	1.0320 Ea (.129 ea)	90-Start up Operation	
B91808		1.419		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6008-132	1	68	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 182 895
Description: Crosstube Assembly		Part Number: D5569-1TRN
Inspection Dwg: D5569 Rev: A		Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Side A	2.870	±.010	2.871	✓		CNC-08	
	2.000	±.030	2.020	✓		CNC-08	
	2.554	±.010	2.554	✓		CNC-08	
Side B	3.220	±.005	3.224	✓		CNC-04	
	3.50	±.030	3.514	✓		CNC-08	
	2.937	±.010	2.937	✓		CNC-08	
	17.50	±.030	17.50	✓		Tape	

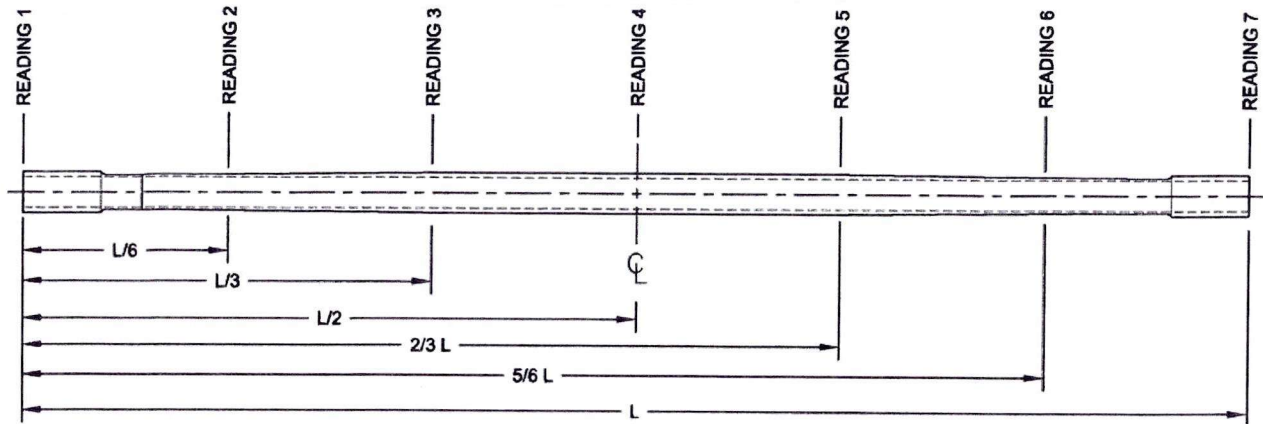
Measured by: MD	Checked by: PD	QC Inspector:
Date: 2016-08-19	Date: 12.10.19	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 182895
Description: Crosstube Assembly		Part Number:
Inspection Dwg:	Rev:	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"						
READING 2 L=						
READING 3 L=						
READING 4 L=						
READING 5 L=						
READING 6 L=						
READING 7 L=						

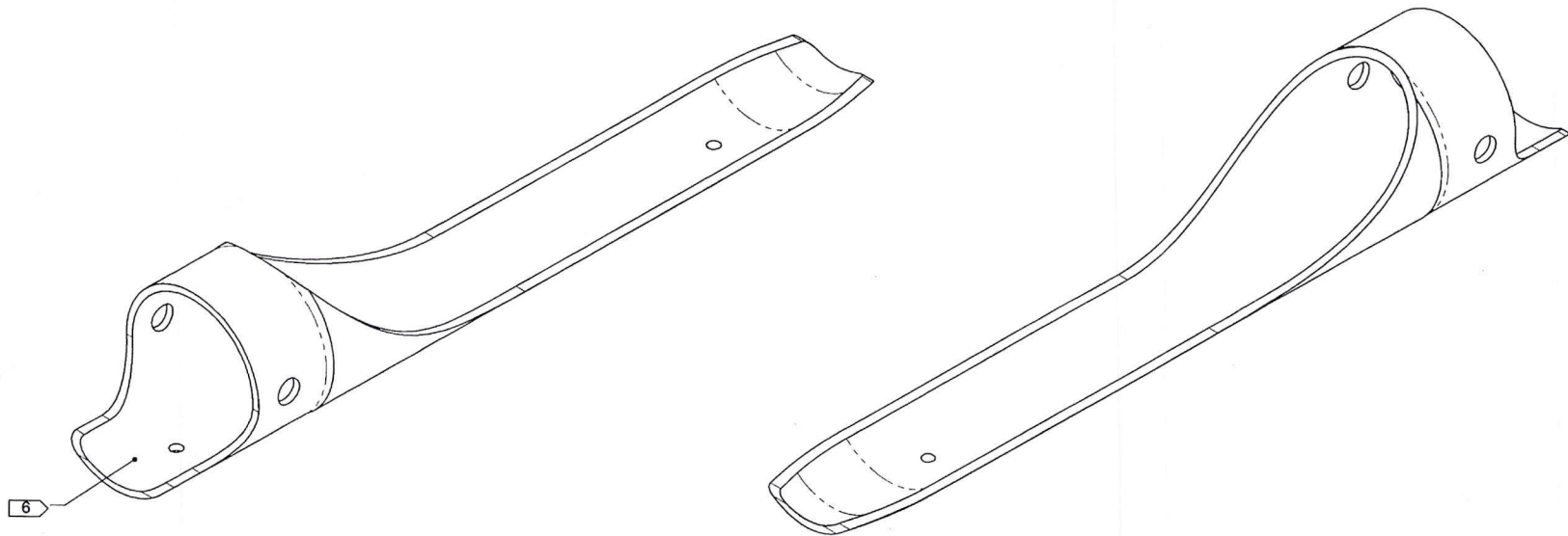
Calibration Result

Actual Block Thickness: _____

SITESCAN 250 Measured Thickness: _____

Measured by:	Audited by:	Preliminary Approval:	
Date:	Date:	Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	
C	12.06.01	Wall thickness form added	KJ	



D5569-1 SKIDTUBE BLADE

NOTES:

- 1) MATERIAL: MAKE FROM D5569-1TRN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.97 lbs

RELEASED

2018 OCT 02 *q*
ECN 18-817

APPROVED

A		NEW ISSUE		ZF	17.09.27
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5569 TITLE SKIDTUBE BLADE COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
DRAWN	ZF				
CHECKED	MW				
MFG. APPR.	RQ				
APPROVED	NO				
DE APPR.	CP	REV. A			
DATE	17.09.27	SHEET 1 OF 3			
		SCALE			
		NTS			

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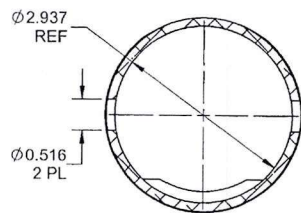
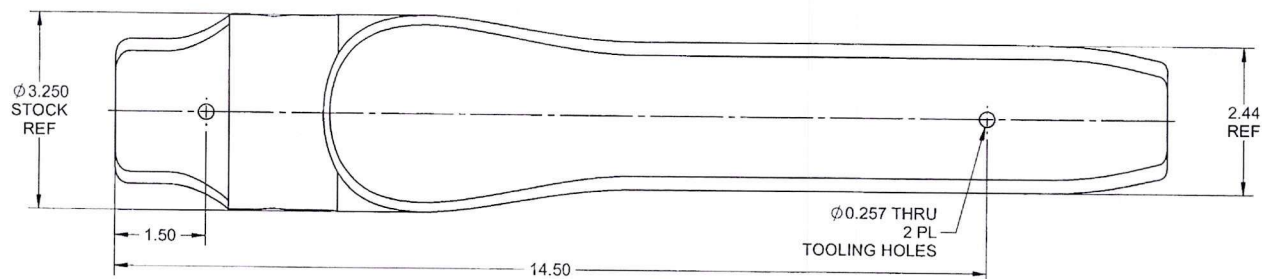
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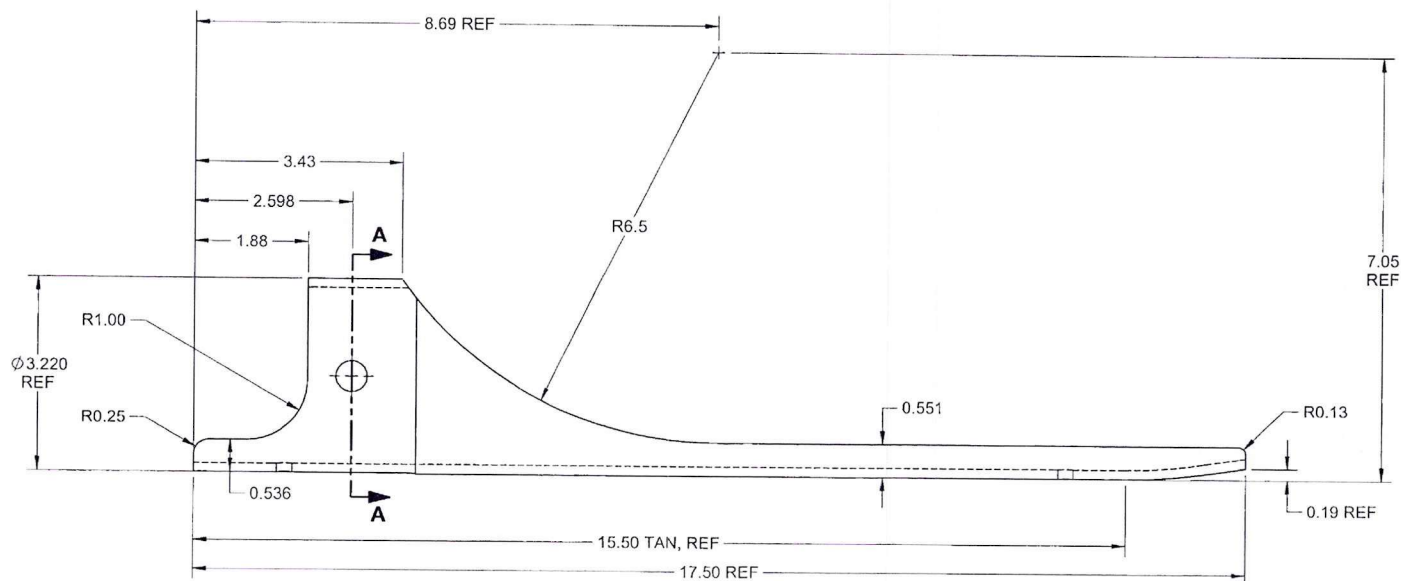
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A



SECTION A-A



RELEASED

2018 OCT 02

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5569	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE BLADE	NTS
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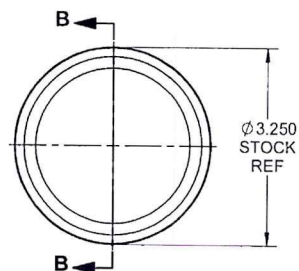
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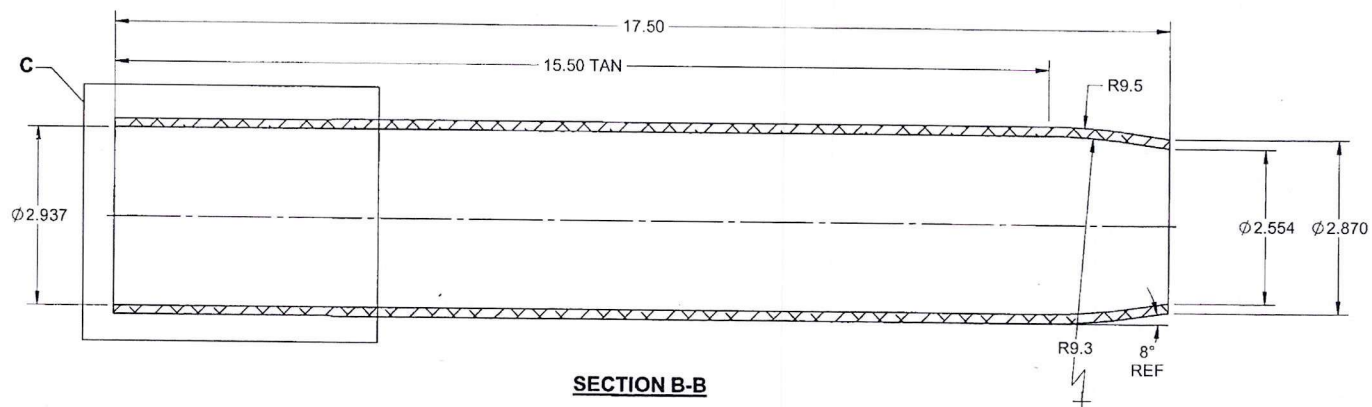
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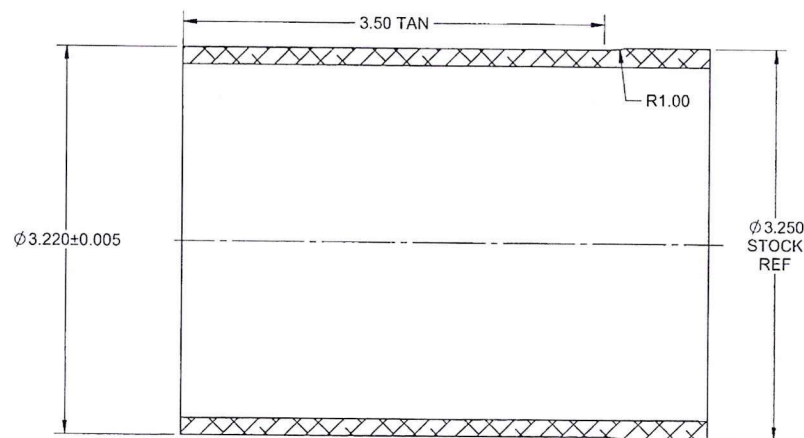
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D5569-1TRN - TURNING DETAIL



SECTION B-B



DETAIL C
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D6008-132
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.62

RELEASED

2018 OCT 02

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DATE

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ZF
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
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TITLE
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REV. A
SHEET 3 OF 3

SCALE
NTS

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